

**Work Order ID 56207**

Tuesday, February 16, 2010 9:03:14 AM

Page 1

Item ID: D3826-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib / Gusset Assembly

Start Date: 2/16/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 2/22/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: *MF* Date: *10-2-16* Tooling:

Date:

Run Start

QC: Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3826

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- use DT9434 to assemble D2325 support gusset together 2- locate D2325 on  
rib and weld as per dwg D38261 A/R ER316 S.S. Rod  
Batch: *113328*

*SH 10/03/09* *(Gx)*

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

*(G)* *plc 10.03.09*

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*8 10/03/09**(46)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 56207**

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Page 2

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Start Date: 2/16/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 2/22/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: basket

0.00



Packaging

Memo

0.00

Packaging

⑥

PD

10.03.09

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/11 *[Signature]*  
MF  
10-3-10

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# Picklist Print

Tuesday, February 16, 2010 9:03:14 AM

Page 1

Work Order ID: 56207



Parent Item: D3826-041



Parent Item Name: Rib / Gusset Assembly

Start Date: 2/16/2010

Required Date: 2/22/2010

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2235-1		Manufactured	No				Each	6.0000	6.0000			
Basket Rib												

Warehouse      Loc Qty      Loc Code  
Location

Main Warehouse  
WA  
50565  
55719

B55979  
6  
3  
3

Each 5.0000 6.0000



~~6x~~ SM 10/03/08  
~~2x~~

D3929-041      Manufactured      No



Gusset Assembly

Warehouse      Loc Qty      Loc Code  
Location

Main Warehouse  
WA  
55720

5  
5

Each 13.0000 6.0000



B56180 1x  
5x

SM 10/03/08

D3929-042      Manufactured      No



Gusset Assembly

Warehouse      Loc Qty      Loc Code  
Location

Main Warehouse  
ST  
50567  
50869

11  
2  
9

Main Warehouse  
WA

2  
2

54730

56181

4x

2x  
4x

SM 10/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

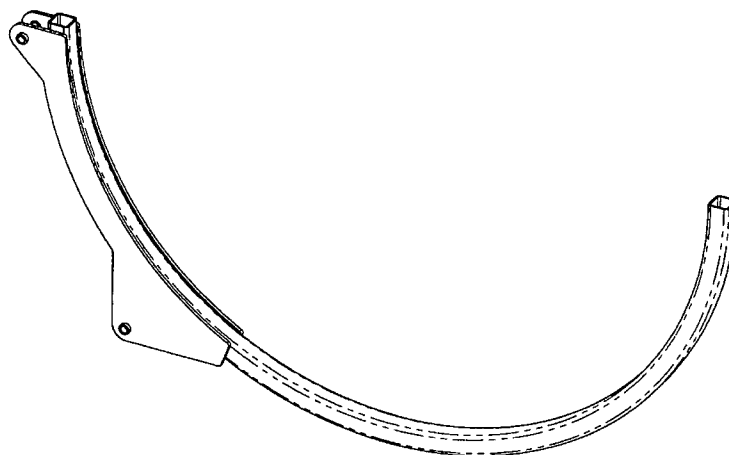
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

#56207



**D3826-041 RIB/GUSSET ASSY**



ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D3826-041	RIB/GUSSET ASSY
11	1	D2235-1	RIB
12	1	D3929-041	GUSSET ASSEMBLY
13	1	D3929-042	GUSSET ASSEMBLY

△/B

RELEASED  
8/6/12

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 3.32 lbs

△/B

B	D3929-041/-042 WERE D2325 (ZN D3-1 & ZN D6-2); UPDATED WEIGHT (ZN A8-1). REASON: SEE NCR#09-042.		MB	09.04.16
A	NEW ISSUE		MB	08.09.23
REV.	DESCRIPTION		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. B SHEET 1 OF 2	
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		TITLE	SCALE	
		<b>RIB/GUSSET ASSY</b>	NTS	
DATE	09.04.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		

# Dart Aerospace Ltd

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8 7 6 5 4 3 2 1

D

D

△ B D3929-042  
GUSSET ASSEMBLY

△ B D3929-041  
GUSSET ASSEMBLY

TYP

#56807

C

C

0.250

C

B

B

D2235-1  
RIB

D3826-041 RIB/GUSSET ASSY

RELEASED  
2/10/16

A

A

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3826	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		RIB/GUSSET ASSY	NTS
DATE	09.04.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8 7 6 5 4 3 2 1

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